

Date: 7 Thursday, 5/10/2007 2:26:43 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 WEB
Job Number	: 32291		
Estimate Number	: 10466		
P.O. Number	: N/A	Part Number	: D33891
This Issue	: 5/10/2007	S.O. No.	: NA
Prsht Rev.	: NC	Drawing Number	: D3389 REV C
First Issue	: NA	Project Number	: N/A
Previous Run	: 31897	Drawing Revision	: C
		Material	: N/A
		Due Date	: 5/30/2007
Written By	:	Qty:	6
Checked & Approved By	: <u>JA 07.05.10</u>	Um:	Each
Comment	: Est Rev:A 05.08.31 New issue KJ/JLM		
	: Est Rev:B 06-02-08 As per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -1' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Ext'n -1' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	B25251

JD 7-5-14

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
 1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open 1X .257" Dia Hole

4-Open Remaining holes to finish size as per Dwg D3389

5-Deburr

PTD

JD 7-5-14

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

JD

7-5-14

PTD

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-5-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/05/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070515	20	0.257" hole was drilled at the 8th hole from the first section of the I-beam. Should have been drilled at the 11th hole. 6 webs drilled the same.	<i>[Signature]</i>	open the 0.257" hole to 0.625" as per Dwg.	JD 7-5-16	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
			<i>Q51042</i>	retrain employee to fully understand the Dwg.	<i>[Signature]</i> 7-5-16	Aug-22	<i>Q51042</i>	070515

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 32291

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

7-5-16

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

JD 7-5-16 (6)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/22

Job Completion



07/05/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

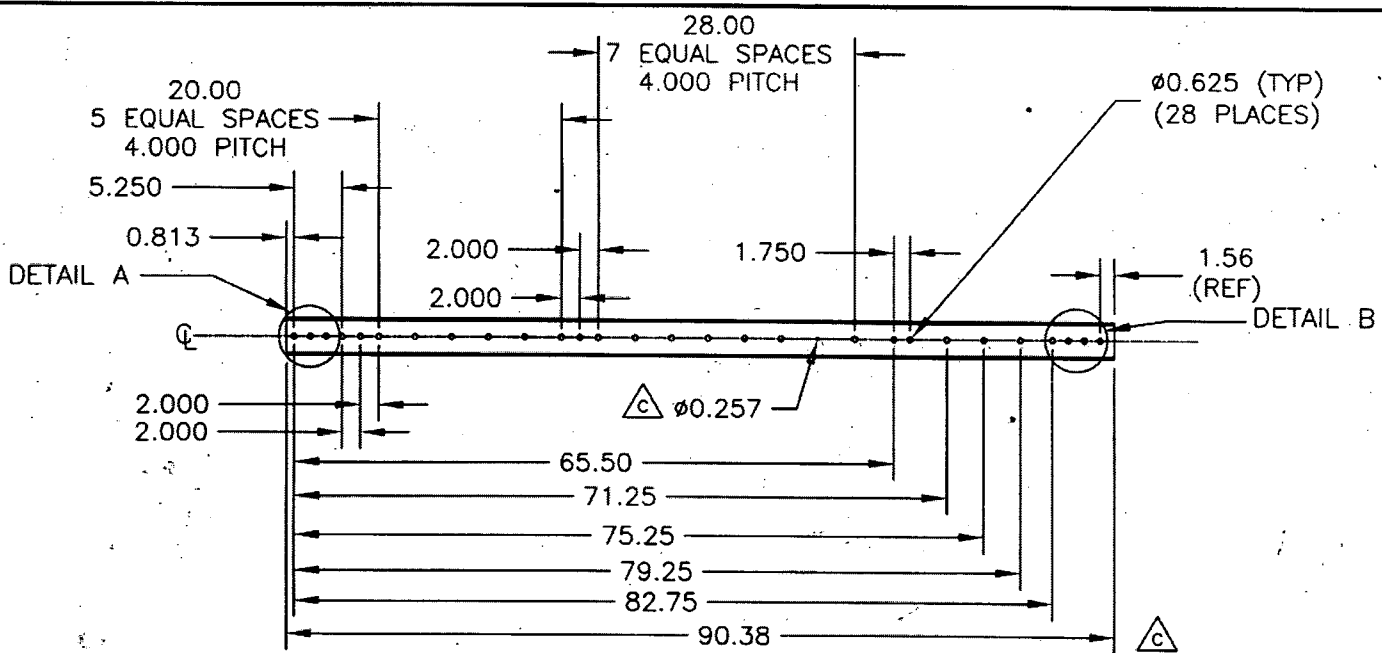
NOTE: Date & initial all entries



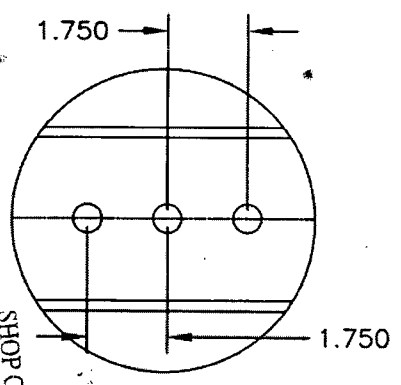
RELEASE

06-01-23

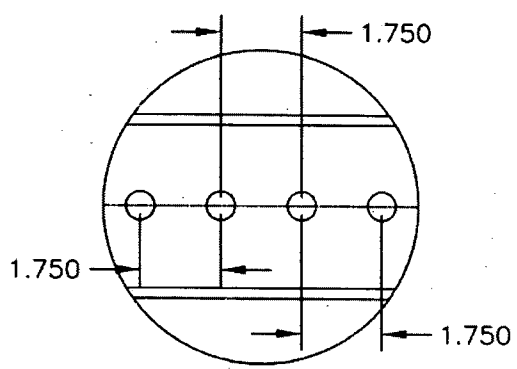
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3389
DATE	TITLE	REV. C
06.01.23	412 WEB	SHEET 1 OF 1
A	05.02.07	NEW ISSUE
B	05.06.13	UPDATE DIMENSIONING
C	06.01.23	DECREASE OVERALL LENGTH, MODIFY HOLE



D3389-1 DRILLING DETAIL



DETAIL A
(SCALE 1:4)



DETAIL B
(SCALE 1:4)

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32291